Work Order ID 54345



Page 1

December 8, 2009 8:49:51 AM

Raquired Date: 16/12/2009

item	ID:	

D3769-5

Accept



Setup Start



Revision ID:

Tube Item Name:

Star: Date: 08/12/2009 **Start Qty: 20.00** Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Tooling:

Date:

Draw

Run

Start

Stop



Sequence ID/

OC:

Date:

SPC (Y/N):

Date:

Draw

Accept **Qty**

Reject

Reject

Insp.

Work Center ID Draw Nbr

Operation Description

Revision Nbr

Set Up/ **Run Hours**

Number Rev. Plan Code

Qty

Number

Stamp

D3769

Rev A

100

Small Fab

Small Fab

Small Fab

0.00

0.00

Memo 1-cut tube to lenght as per dwg D3769 2-drill holes thru on both ends of tube as

per dwg D3769 using DT9411 Jig 3- deburr

110

QC5- Inspect part completeness to step on W/O

0.00

27 S coloclog

OC

Quality Control

Memo

BR 10-01-7

120

HandFinish

Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				<u> </u>
DATE	STEP	PR	PROCEDURE CHANGE						Approval QC Inspector
								Prod Mgr	
		'1		v					
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DO	QA:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NC	R)			
	DATE STED Description of NC			Corrective Action Section B			fication Approval		Approval
DATE STEP Descript	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Se	ction C	Chief Eng	QC Inspector	
				•					
e								·	
						1			

NOTE: Date & initial all entries

Work Order ID 54345

Quality Control



Page 2

December 8, 2009 8:49:51 AM Item ID: D3769-5 Accept Setup Start **Revision ID:** Stop Item Name: Tube **Start Date:** 03/12/2009 Start Qty: 20.00 $P_{\mathbf{k}}$ **Cust Item ID:** Required Date: 16/12/2009 Req'd Qty: 20.00 809 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Plan Reject Reject Draw Accept Insp. **Work Center ID** Description Code **Run Hours** Number Rev. Qty Number Qty Stamp 130 QC3- Inspect Part Finish 0.00 0.00 Memo Quality Control 140 Identify as per dwg & Stock Location: 0.00 Packaging 0.00 Memo Packaging 150 QC21- Final Inspection - Work Order Release 0.00 0.00 Memo

> MF 10-01-07

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES							
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
				·	-		1:1					
							,					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DO	QA:	Date: _				
	R	esolution:	Disposition	1:	QA: N/C Closed: Date:							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)						
DATE	STEP	Description of NC		Corrective Action Section B			ication	on Approval	Approval			
DATE STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		tion C	Chief Eng	QC Inspector			
	i.											
				•								

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 8:49:55 AM

Work Order ID: 54345

Parent Item: D3769-5

Parent Item Name: Tube

Comments:

Start Date: 08/12/2009

Required Date: 16/12/2009

Page 1

Start Otv: 20.00

Required Oty: 20.00

								•			110	quirou Qiji 2	0.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	•	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	58.3994	35.2463				

6061T6 RD TUBE 1.00 x .065w

Warehouse Loc Oty Loc Code Location Main Warehouse MAT 58.3994082 110778 2.18 111029

56.2194082

M113511

30 X

Dart Aerospace Ltd

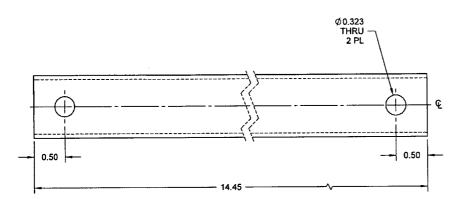
W/O:			V	VORK ORDER CHANG	ES						
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		7.									
							<u></u>				
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No DQ	A:	Date: _			
				Disposition: Q			QA: N/C Closed: Date: _				
NCR:				DER NON-CONFORMA							
DATE	STEP	Description of NC		Corrective Action Section E			cation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		ion C	Chief Eng	QC Inspector		
									,		
							-				

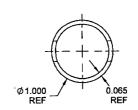
NOTE: Date & initial all entries

3 SHOP CV 311 RETURN O ENGINEE: + UNCONTROL! 1 SUBJECT TO Add 1 WITHOUT '. . . . С Contract Contract **D3769-1 TUBE D3769-3 TUBE** D3769-5 TUBE A NEW ISSUE HS 08.06.04 BY DATE DESCRIPTION REV. NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-220/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3769-1, 0.27 lbs D3769-3, 0.28 lbs D3769-5, 0.37 lbs DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3769 MFG. APPR. SHEET 1 OF 4 TITLE SCALE APPROVED TUBE NTS DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD

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D3769-1 TUBE

DESIGN HS DRAWN HS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3769 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE TUBE DE APPR. NTS

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Ø0.323 THRU -2 PL 0.065 REF Ø1.000 REF 0.50 0.50

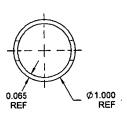
D3769-3 TUBE

W/O 54345

DESIGN	HS	DART AERO	SPACE LTD
DRAWN	HS	HAWKESBURY, ON	TARIO, CANADA
CHECKED	RA	DRAWING NO.	REV. A
MFG. APPR.	W	D3769	SHEET 3 OF 4
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DE APPR.		TUBE	NTS
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D3769-5 TUBE

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DRAWN	HS	HAWKESBURY, C	NTARIO, CANADA						
CHECKED	pet	DRAWING NO.	REV. A						
MFG. APPR.	77-	D3769	SHEET 4 OF 4						
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